

Work Order ID 55646

January 26, 2010 1:41:51 PM

Page 1

Item ID: D3999-9

Revision ID:

Item Name: Angle

Start Date: 1/26/10

Start Qty: 1.00

Required Date: 2/03/10

Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3999

A-~~PRELIM~~

Rev. A

100

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: PRE

Prog Rev: Lim

2-Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

PRELIMINARY ISSUE



Setup Start

Stop

Cust Item ID:

Customer:



HB 10-1-27

GP 10/01/28

6

HB 10-1-27

Pto =>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	130	Bend as per Dwg D3999 perm. chg	SB	10/01/28	5		S 10/01/28	
	140	QC 5 8 10/01/28 (x6) perm. chg	S	10/01/28	x6		S 10/01/28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55646

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Page 2

Item ID: D3999-9

Accept

Revision ID:

Item Name: Angle

Start Date: 1/26/10

Start Qty: 1.00

Required Date: 2/03/10

Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run-Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

no changes to PA1 to Rev A Dwg
not inspectors to release Dwg.

170

Identify as per dwg & Stock Location: *prelim*

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
10-2-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 26, 2010 1:41:51 PM

Page 1

Work Order ID: 55646

Parent Item: D3999-9

Parent Item Name: Angle

Comments: IPP rev A 10.01.20 new issue Prelim EC verified by:DD

Start Date: 1/26/10

Required Date: 2/03/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	316.0657	0.0248	2		



6061-T6 .063 Sheet



AB 10-1-27

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse			
	MAT	316.0657211	
	110551	25.4841211	
	112939	2.5816	
	113608	288	

6

POSITIVE RECALL
EFFECTIVE 01.21.27 AUTH
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

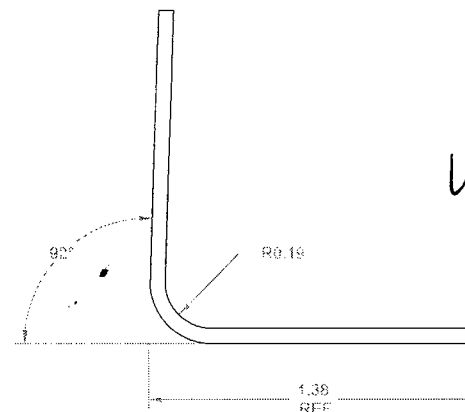
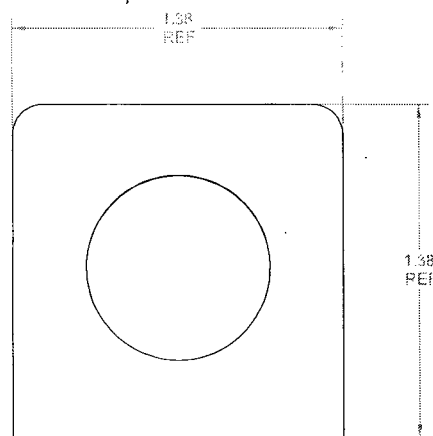
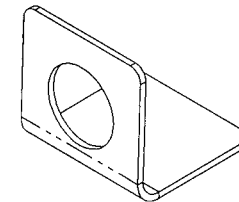
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D3999-9

JOHN CAMERON AVIATION
PART NUMBER

JCA-M47-1-18



WLO
55648

D3999-9 ANGLE

PRELIMINARY ISSUE

09.10.07

NOTES:

- 1) MATERIAL: MADE FROM D3999-9F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN

DRAWN

CHECKED

MFG. APPR.

APPROVED

DE APPR.

DATE 09.10.07

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3999

TITLE

BAFFLE

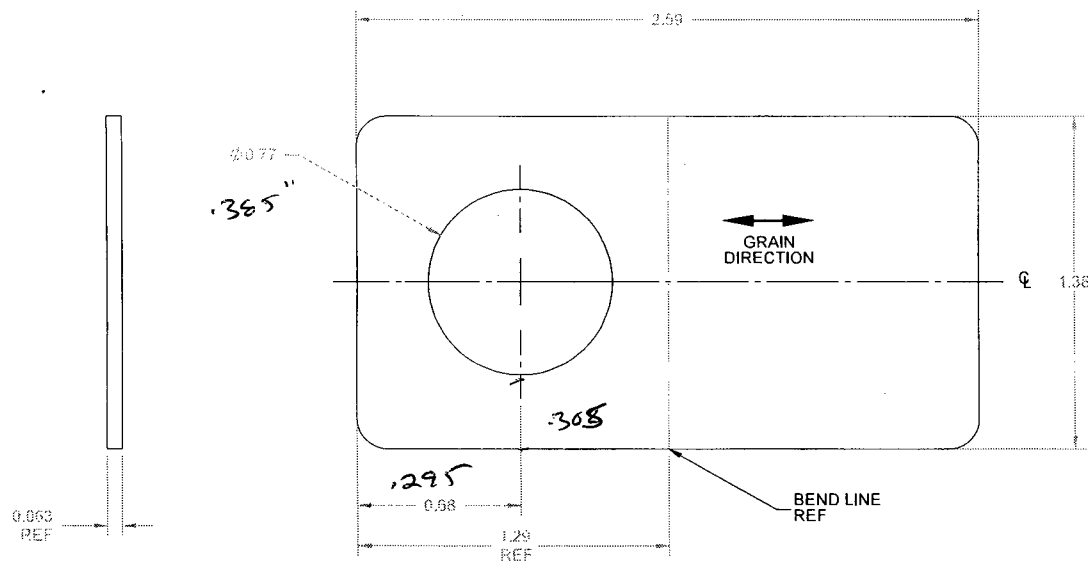
REV. PA1

SHEET 9 OF 12

SCALE

NTS

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D3999-9F FLAT PATTERN

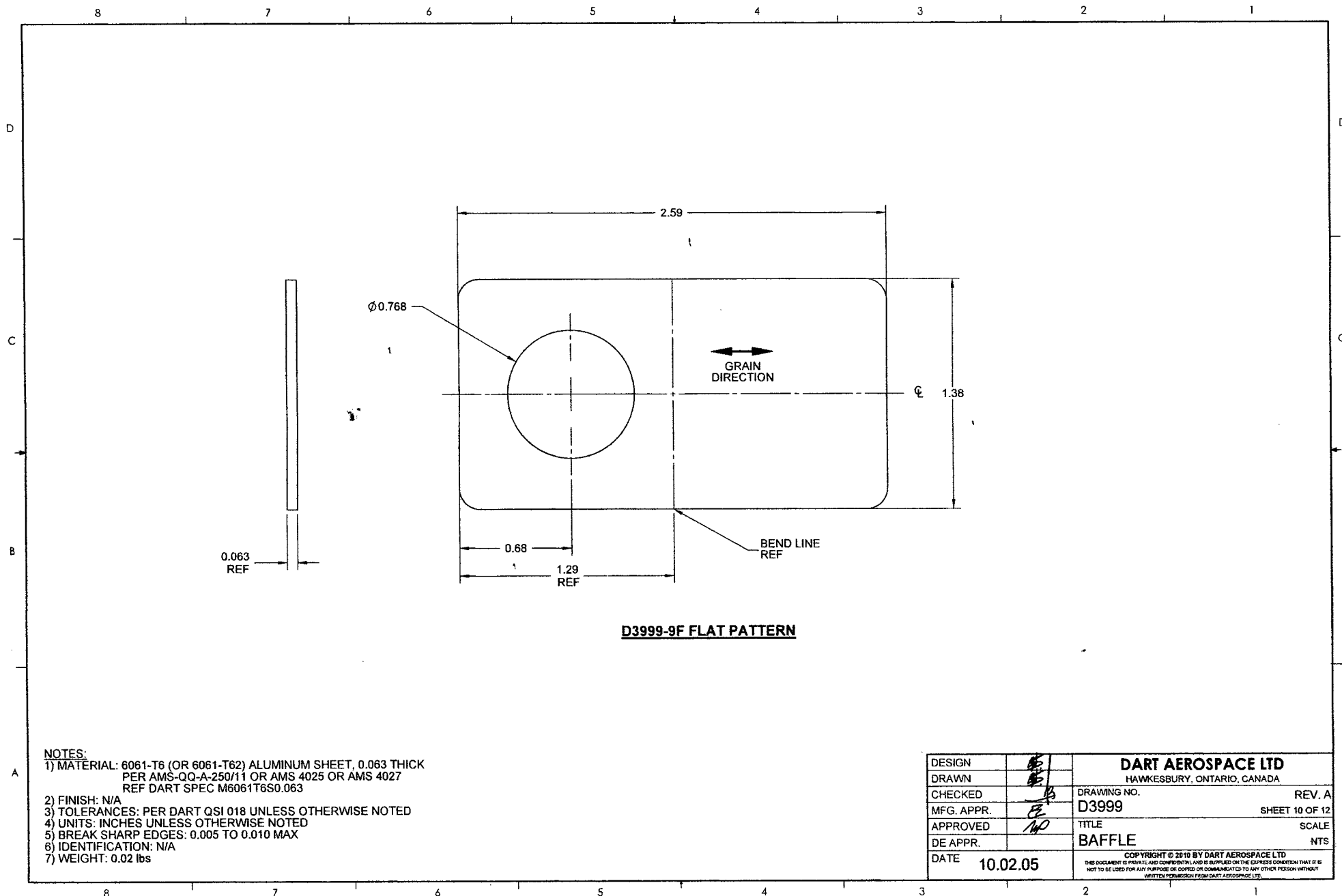
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S0.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 7) WEIGHT: 0.02 lbs

PRELIMINARY ISSUE

09.10.07

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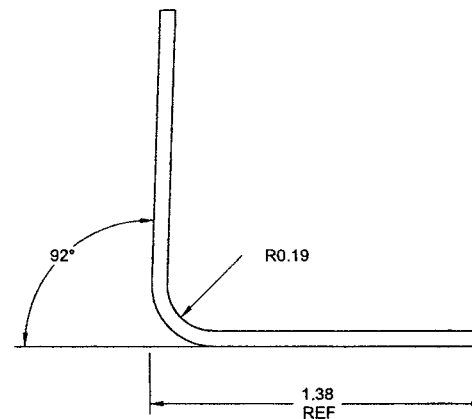
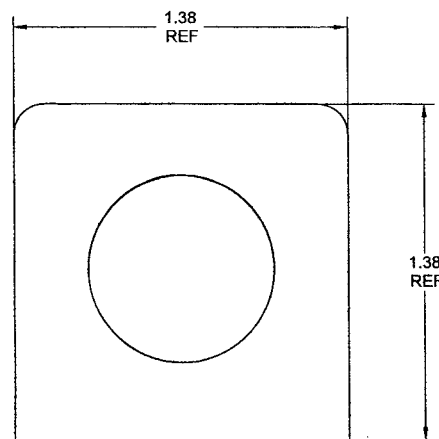
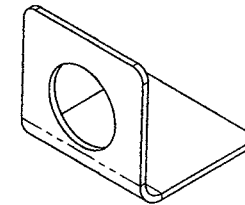


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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-9	JCA-M47-1-18



D3999-9 ANGLE

NOTES:

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- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
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